

Split  
Today 11/05  
Work Order ID 68830-1

Thursday, April 21, 2011 11:33:31 AM

Page 1

Item ID: D2332-041

Accept

Revision ID:

Item Name: Lid Prop Assembly 6.69" long

Start Date: 4/21/2011 Start Qty: 10.00

Required Date: 4/26/2011 Req'd Qty: 10.00

Reference:

Approvals: Process Plan: CL

QC:

Date: 11/04/21 Tooling:

Date: SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2332

Rev C1

100

0.00

Small Fab

Memo

0.00

1- Cut D2332-7 and D2332-5 to length as per dwg D2332

2- Cut D2332-11 using 1/2" S.S tubing 7.735" long

3- Debur.

110

0.00

Brake NC

Memo

0.00

Punch and form D2332-11 to length as per dwg D2332 using DT8012  
( need 2 per ass'y)

Brake NC

11/05/11

Pro →

11/05/11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2332-13 PAR #: W/P Fault Category: Small FAB NCR: (Yes) No DQA: 12 Date: 11.05.17  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ck Date: 11/05/17

NCR: <u>368830</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>11/05/17</u>	<u>#120</u>	<u>Found D2332-13 to be made too long. Length from center to center is 6.897". Should be 6.650"</u>	<u>JB</u> <u>as per</u>	<u>→ Scrap + Destroy</u> <u>And Replace</u> <u>in H115990 H116720</u>	<u>JB</u> <u>11/05/17</u>	<u>8</u> <u>11/05/17</u>	<u>JB</u> <u>as per</u>	<u>8</u> <u>11/05/17</u>
		<u>RL not formed correctly</u> <u>Lack of Altitude.</u>	<u>/</u>	<u>/</u>	<u>/</u>	<u>/</u>	<u>/</u>	<u>8</u> <u>11/05/17</u>

NOTE: Date & initial all entries

**Work Order ID 68830**

Thursday, April 21, 2011 11:33:32 AM

Page 2

Item ID: D2332-041

Accept

Revision ID:

Item Name: Lid Prop Assembly 6 69" long

Start Date: 4/21/2011 Start Qty: 10.00

Required Date: 4/26/2011 Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

0.00



Small Fab

Memo

0.00

1- Drill hole in D2332-11 as per dwg D2332 using drill jig DT8459  
(drill one per ass'y)

2- Ensure no foreign objects inside tube

3- Debur

130

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

140

0.00



Large Fab

Memo

0.00

Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y)  
\*\*\*\*\*ensure nothing is inside of tube before welding\*\*\*\*\*

S.S. Rod batch: 115928



Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Stop

*Handwritten signature: G. B. / 05/11*

*Handwritten circled 'X5'*

*Handwritten signature: G. B. / 11-05-11*

*Handwritten circled '5x'*



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 68830

Thursday, April 21, 2011 11:33:32 AM



Page 3

Item ID: D2332-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lid Prop Assembly 6.69" long

Start Date: 4/21/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/26/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00

*Handwritten: BE 11-05-11*

*Handwritten: 5*

*Handwritten: 0*



QC

Memo

0.00

Quality Control

160

QC5- Inspect part completeness to step on W/O

0.00

*Handwritten: 8 11/05/11*

*Handwritten: (XJ)*



QC

Memo

0.00

Quality Control

170

Memo

0.00



Small Fab

1- Tumble

0.00

*Handwritten: SB 11/05/12*

*Handwritten: 11-5-12*

*Handwritten: 5*

*Handwritten: 5*

Small Fab

2- Assemble as per dwg D2332

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 68830

Thursday, April 21, 2011 11:33:32 AM



Item ID: D2332-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lid Prop Assembly 6 69" long

Start Date: 4/21/2011 Start Qty: 10.00



Cust Item ID:

Required Date: 4/26/2011 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

190

Identify as per dwg & Stock Location ST 512 0.00



Packaging

Memo

0.00

Packaging

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

8 4/25/12

(43)

ME 11-05-13

11/5/16

ME 11-05-13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



# Picklist Print

Thursday, April 21, 2011 11:33:27 AM

Page 1

Work Order ID: 68830

Parent Item: D2332-041

Parent Item Name: Lid Prop Assembly 6.69" long



Start Date: 4/21/2011

Required Date: 4/26/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: B 02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/RF  
IPP Rev:C 08-06-02 add comment DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304R.250

Purchased

No

100

f

12.7800

0.1

1.052632



304 SS Round bar .250

Location

Loc Qty

Loc Code

MAT028

12.78

114482 ✓

12.78

M304TR1.000W.049

Purchased

No

100

f

19.6600

0.43

4.526316



304 RD Tube 1.00 x .049W

Location

Loc Qty

Loc Code

MAT018

19.66

108756 ✓

7

111457

12.66

M304TR0.500W.035

Purchased

No

110

f

11.7907

1.25

13.15789



304 RD Tube 500 x .035W

Location

Loc Qty

Loc Code

MAT017

11.79068

115535

2.33

115990 ✓

5.29

116720 ✓

4.17068

m-l 11/04/29

1-052632

m-l 11/04/28

4-526316

Sn 11/04/28

2-525.29  
5.510

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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# Picklist Print

Thursday, April 21, 2011 11:33:27 AM

Page 2

Work Order ID: 68830

Parent Item: D2332-041

Parent Item Name: Lid Prop Assembly 6.69" long

Start Date: 4/21/2011

Required Date: 4/26/2011

Start Qty: 10.00

Required Qty: 10.00

AN4-4A Purchased No

170

Each

122.0000

1

10



Bolt



SA 11/05/12

⑤

Location

Loc Qty

Loc Code

FP-B

48

114615

48

ST356

74

114615

74

AN960JD416L NAST149D0416J Purchased No

170

Each

5.0000

3

30



Washer



SA 11/05/12

⑤

Location

Loc Qty

Loc Code

FP-B

5

110153

5

1114103

5

MS21042L4 Purchased No

170

Each

5.333.000

1

10



Nut



SA 11/05/12

⑤

Location

Loc Qty

Loc Code

ST300

5333

116188

333

116823

2000

117441

3000

5

Thursday, April 21, 2011 11:33:28 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_






Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

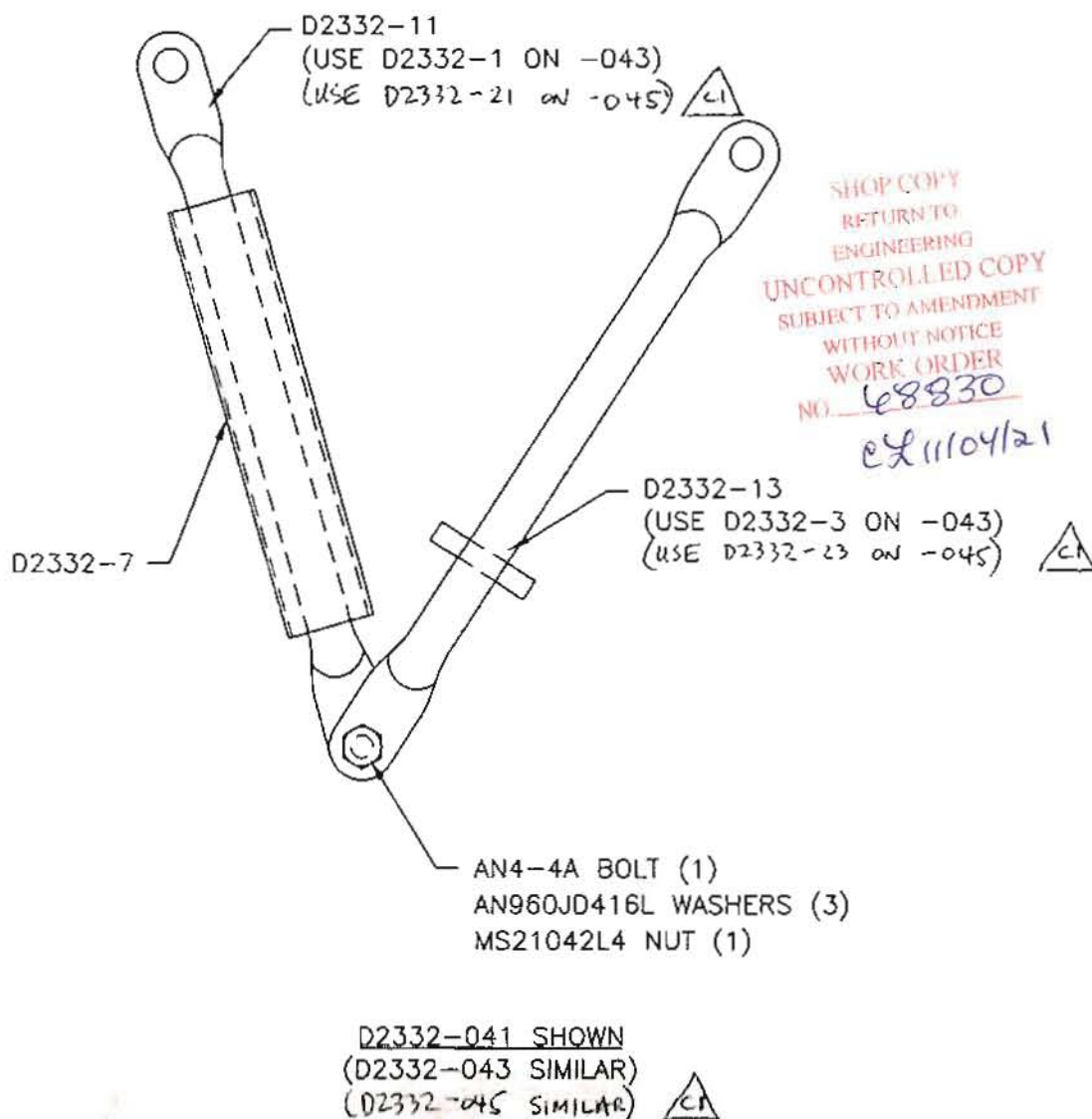
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



**DART**

DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
CHECKED 	APPROVED 	DRAWING NO. D2332	REV. C SHEET 1 OF 2		
DATE 03.07.03		TITLE LOD PROP ASSEMBLY	SCALE NTS		
A	94.12.16	NEW ISSUE			
B	97.09.30	CHANGE 416 WASHERS TO 416L			
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)			
C1 	03.08.06	ADD -045 PROP (7.25" LONG)			

RELEASED  
03.07.04 *[Signature]*

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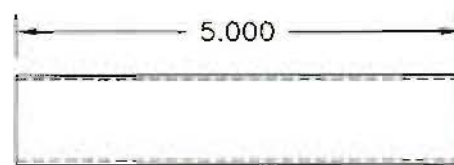
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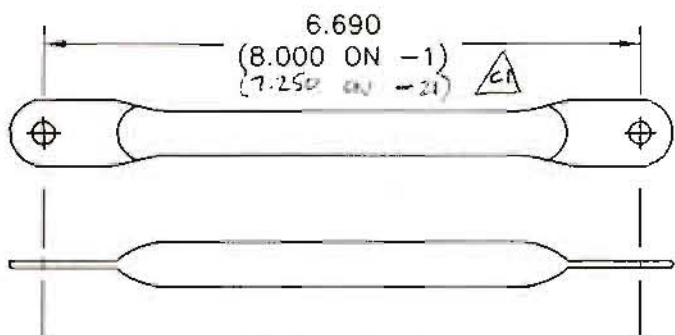
**DART**



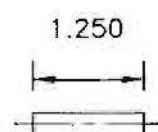
DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2332	REV. C
DATE 03.07.03		TITLE LID PROP ASSEMBLY	SHEET 2 OF 2
C	03.07.03	MATE - 041 PROP 6.6" LONG (END)	SCALE 1:2
C1	03.08.06	MATE - 043 PROP 8.00" LONG (END)	
		ADD - 045 PROP (7.125" LONG)	



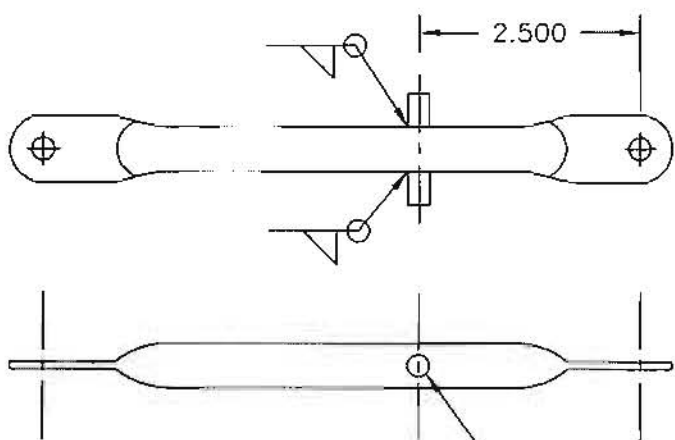
D2332-7 LOCKING COLLAR



D2332-11 PROP  
(D2332-1 SIMILAR)



D2332-5 STOP PIN



D2332-13  
M/F D2332-11 & D2332-5  
{D2332-3 SIMILAR - M/F D2332-1 & D2332-5}  
{D2332-23 SIMILAR - M/F D2332-21 & D2332-5}



NOTES:

1. MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035  
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250  
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
2. TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 48830

RELEASED  
b3 01 01

6459